



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3213-3
Job Sheet 170440



Part No: D3213-3

Job Qty: 5 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now on Waterjet 07-02-13 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		1/30/18	0.00	0.00	Start Up Waterjet		SC 18/01/24
100	Waterjet	5 pcs		1/30/18	0.03	0.22	Waterjet1		SC 18/01/24
120	QC	5 pcs		1/30/18	0.00	0.00	QC8		38
140	HandFinish	5 pcs		1/31/18	0.00	0.31	HandFinish1		2018/01/24 JLM
150	QC	5 pcs		1/31/18	0.00	0.00	QC7-2		38
160	Packaging	5 pcs		1/31/18	0.00	0.00	Packaging3	17-484	AT 9-88 18/01/26
170	QC21-SA	5 Ea		1/31/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - CUT AS PER DWG DWG REV: B PROG REV: B

DWG
21
9-88

FEB 26 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M202413S.063	2	321	0	0
	M138389	2,926			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	15.000inches $\pm$ 0.030	15.030 14.970	15.00	
2	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0.398	
3	Door Panel	14.400inches $\pm$ 0.010	14.410 14.390	14.40	
4	Door Panel	0.128inches + 0.005 - 0.001	0.133 0.127	0.129	
5	Door Panel	4.420inches $\pm$ 0.030	4.450 4.390	4.428	
6	Door Panel	1.000inches $\pm$ 0.030	1.030 0.970	0.998	
7	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0.301	
8	Door Panel	2.057inches $\pm$ 0.005	2.062 2.052	2.058	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐																																																																																																													
Date: _____ Step #: _____		Suspended ☐		MRB (QSI042) Approval _____																																																																																																													
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Root Cause		Completed By _____ Hand / Supervisor approval Verification _____ QC / QA Coordinator Approval _____																																																																																																															
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